

Date: Thursday, 6/21/2007 2:29:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE
Job Number : 33061	
Estimate Number : 10316	
P.O. Number : <i>N/A</i>	Part Number : D2680041
This Issue : 6/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2680 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 30446	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/28/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: D 04-10-01 Added Steps 2-4, 7-8 KJ/JLM	
Est Rev:E Now on WaterJet 06-10-12 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.0138 sf(s)/Unit Total : 0.5502 sf(s)

1010/1025/A21/6aA SHEET .063" thk

Batch: *M104421**SAD 07/06/24*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2680

Dwg Rev: *B1*Prog Rev: *B1*

2-Deburr if necessary

*SAD 07/06/24**(40)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/06/24**(40)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*En 07/06/25**counted (+40)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D2680

*m/07/06/27**x40*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING



M104144



(40X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

07/06/30

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

07-07-05

8.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty

Part Number Description

Batch

2

MS20426AD3-3

Rivet

M1563

9.0

MS21069L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty

Part Number

Description Batch

1

MS21069L4

Nut Plate

M110152 (29+)

M18536 (11X)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

mf

07-07-05

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Aut-09

counted
(846)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5744

27/7/8 (40)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 12/10/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

Box 107/09

Job Completion



C207/07/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

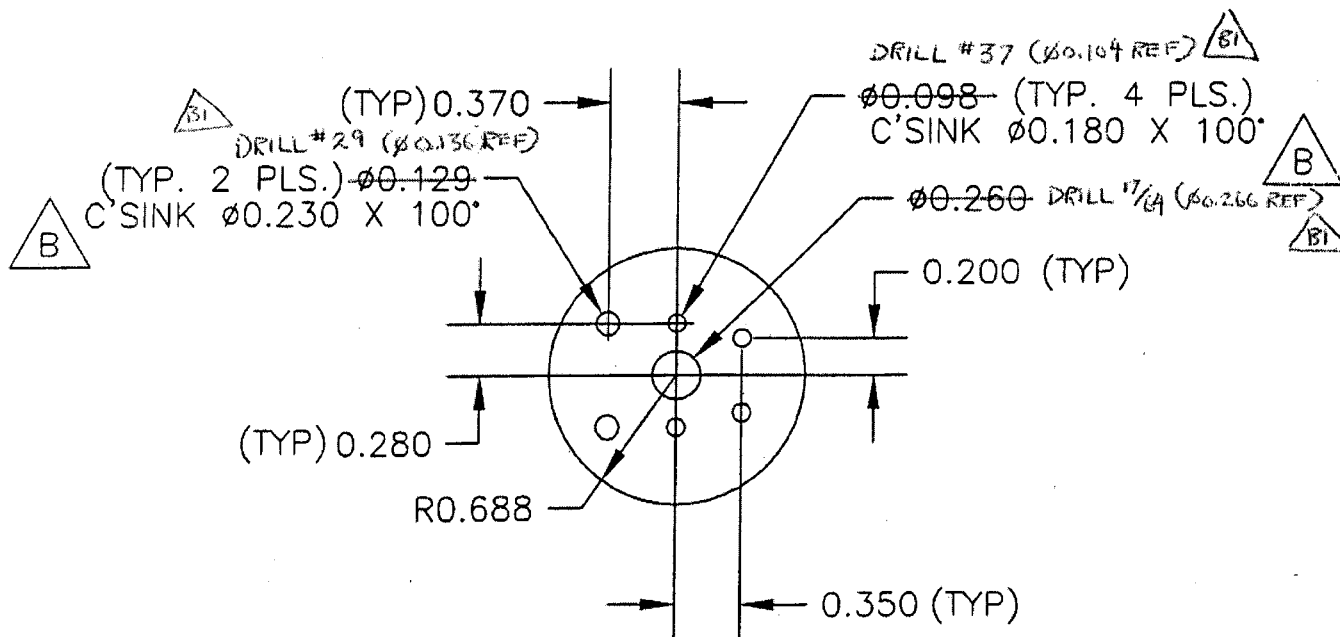
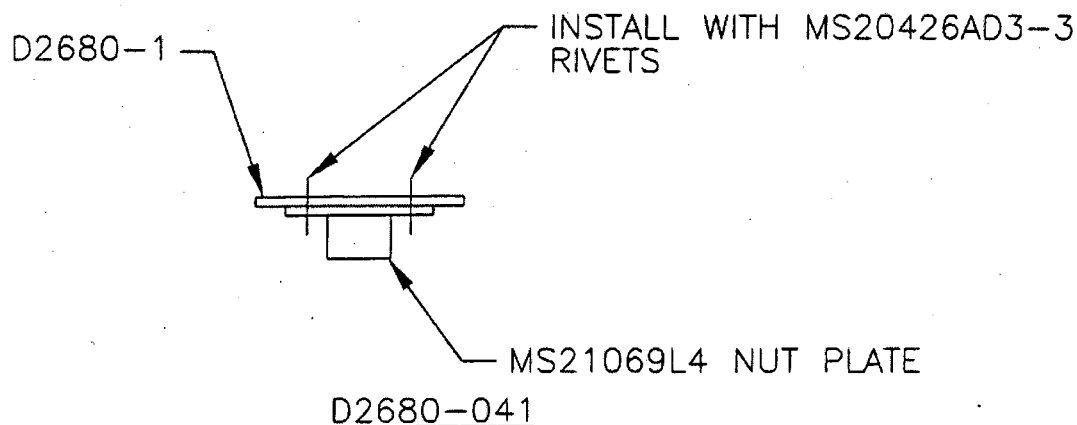
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14		TITLE NUT PLATE	SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	CP # 04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

GAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

POWDER COAT WHITE (4.35.2) PER DART QSI 005 4.3
D2680-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33061